

Work Order ID 128346***128346***

Page 1

Item ID: D350-616-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Full Emergency Litter

Start Date: 1/15/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/30/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr**Revision Nbr**

D350-616

G

0.00

DAS
06
9-09

ML5 1501-22

100

Document Control

0.00

100

DC

Memo

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D350-616-011
CHG006

JAN 29 2015

101

0.00

101

Small Fab

Memo

0.00

Small Fab

1- Assemble as per Dwg D2370

2- Transfer drill using D4812-041 as template and open to size 0.257" as per
Dwg D2370 AND DT9935 DRILL JIG

3- Ensure fit of D4812-041 and remove for shipping

D4812-041 MUST STAY WITH LITTER FRAME

4- Deburr

I FF

JAN 22 2015

DAS
28
9-09

January-15-15 2:08:04 PM

Item ID: D350-616-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Full Emergency Litter

Stop *NS2*

Start Date: 1/15/15 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 1/30/15 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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105 QC5- Inspect part completeness to step on W/O

0.00

105

OC

Memo

0.00

Quality Control

JAN 22 2015

119 Pick Kit

0.00

119

Packaging

Memo

0.00

Packaging

DAS
28
9-89

JAN 29 2015

120 QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

**DAS
OG
S-50**

JAN 23 1971

Work Order ID 128346

128346

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January-15-15 2:08:04 PM

Item ID: D350-616-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Full Emergency Litter
 Start Date: 1/15/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/30/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-616-011								
	Location: <u>P6031</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
06
100

JAN 29 2015

MLJ 1501-30

WISOL-30

Picklist Print

January-15-15 2:08:04 PM

Page 1

Work Order ID: 128346

128346

Parent Item: D350-616-011

D350-616-011

Parent Item Name: Full Emergency Litter

Start Date: 1/15/15

Required Date: 1/30/15

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP E03.04.04ReformatKJ/RF

IPP Rev:F 08-12-10 rev.E as per dwg DD verified by:ec IPP REV:G

13.05.21 AS PER DWG REV.G DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2370-1		Manufactured	No				Each	0.0000		1			
D2370-1									**	<u>1</u>	<u>FF</u>	<u>JAN 22 2015</u>	
Litter Frame Assembly													
D350-616-013		Manufactured	No				Each	0.0000		1			
D350-616-013									**	<u>128648</u>		DAS	
Deck Plate & Tie Down												28	
D4812-041		Manufactured	No				Each	7.0000		1			
D4812-041									**	<u>FF</u>		<u>JAN 22 2015</u>	
Patient Stop Assembly													

Location

Loc Qty

Loc Code

ST371

7

124394

1

126501

6

1

ITEM	QTY	P/N	DESCRIPTION
	X	D2370-041	LITTER ASSEMBLY
1	1	D2370-1	LITTER FRAME ASSY
2	1	D4812-041	PATIENT STOP ASSY

W/O 128346

D2370-1 LITTER FRAME ASSEMBLY

D4812-041 PATIENT STOP ASSY

POSITION PATIENT STOP OVER
FWD STUDS AND SECURE
WITH PIP PINS

D2370-041 LITTER ASSEMBLY

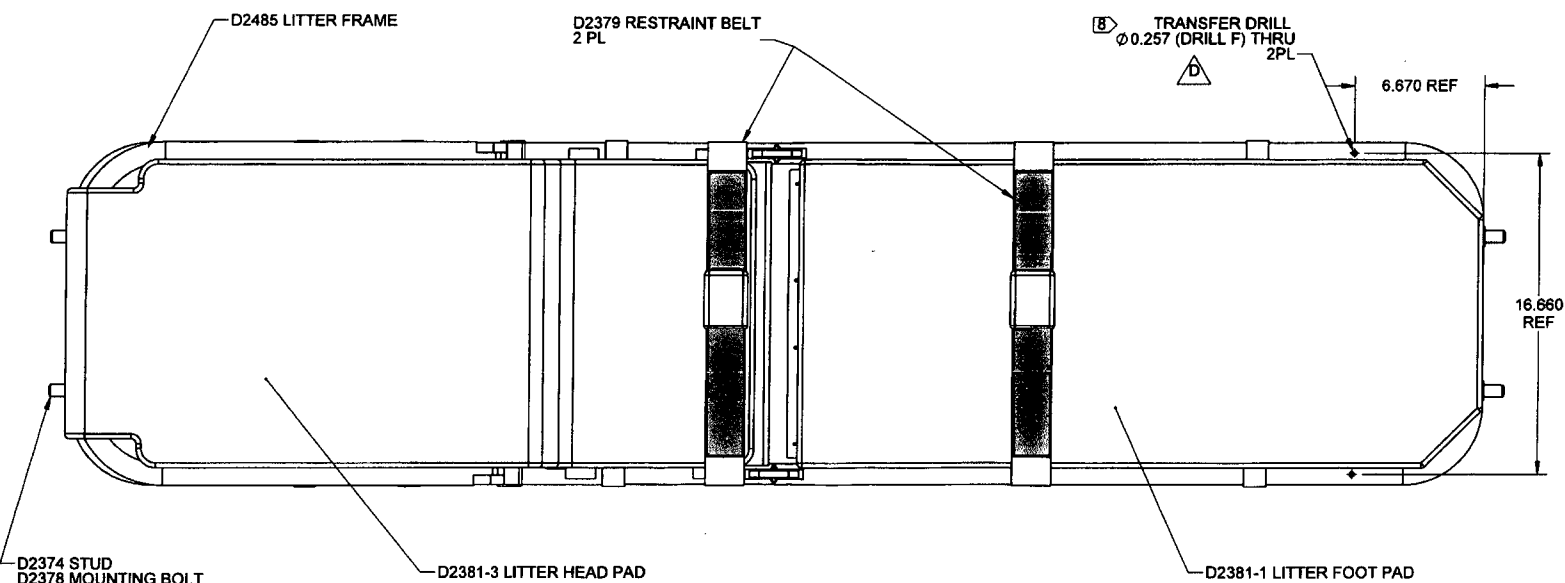
RELEASED
2013-05-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 25.73 Lbs

D	0.0257 HOLES WERE 0.0191 HOLES, 2PL (ZN C3-2), CREATED -1 AND -041 ASSEMBLIES, NEW DWG FORMAT	DB	13.03.27
C	ADD ALTERNATE FOR D2484, MS SCREWS, TAPPED HOLES AND 5.00 WAS 5.34	KE	06.11.21
B	ADDED 0.0191 HOLES	KE	98.06.09
A	NEW ISSUE	NA	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2370 REV. D SHEET 1 OF 2 TITLE LITTER ASSEMBLY SCALE NTS COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	DB		
CHECKED	AP		
MFG. APPR.	AP		
APPROVED	AP		
DE APPR.	AP		
DATE	13.03.27		

ITEM	QTY -1	P/N	DESCRIPTION
	X	D2370-1	LITTER ASSEMBLY
1	4	D2374	STUD
2	4	D2378	MOUNTING BOLT
3	2	D2379	RESTRAINT BELT
4	1	D2381-1	LITTER FOOT PAD
5	1	D2381-3	LITTER HEAD PAD
6	4	D2484	LOCK NUT
7	1	D2485	LITTER FRAME
8	4	AN960JD416L	WASHER



D2370-1 LITTER ASSEMBLY

RELEASED
2013-05-16

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2370-1" USING A REMOVABLE TAG AS PER QSI 044 METHOD 6.6
 - 7) WEIGHT: 24.69 Lbs
 - 8) TRANSFER DRILL USING D4812-041 AS TEMPLATE. ENSURE FIT AND REMOVE FOR SHIPPING

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO. D2370	REV. D
MFG. APPR.	AP	TITLE LITTER ASSEMBLY	SHEET 2 OF 2
APPROVED	AP	SCALE	NTS
DE APPR.	AP	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
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